



8181

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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RB H4749
Job Sheet 189081



Part No: RB H4749

Job Qty: 5 pcs

Part Name: Drain Hose



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/18/19

Job Tracking No:

Due Date: 2/8/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RB H4749 Rev 5A IPP Rev A 18.03.12 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	5 pcs	2/8/19	2/8/19	0.00	0.63	Small Fab - 1		
							Small Fab - 2		MLC
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	5 pcs	2/8/19	2/8/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
130	Packaging 3-1 - Stock - B4B	5 pcs	2/8/19	2/8/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		DAS 26 9-89
							Packaging 3 - 6 - B4B		



Container No: S154491



Part: RB H4749

Job No: 189081

Serial No/Batch: S154491

Revision: 5A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
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Date: 02/16/19

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					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - FG	5 pcs	2/8/19	0.00 0.00	QC 21 - FG - 21	QC 21 - FG - 70	DAS 21 FEB 19 2019 9-00

Part Op 100 - (Small Fab) 1- Cut tube (2044T47) as per DWG 2- Assemble as per DWG Install a 1.0" long, 0.38" OD, 0.25" ID
 Descriptions: piece of Stainless Steel into one end of the Kuri-Tech Hose until flush. Attach the modified end of the Kuri-Tech Hose to the Coupling before placing tool into packaging (if applicable).

110 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: _____) Identify and Stock

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
2044T47	Tube Ø1.09	2.4000 ft (.48 ea)	100-Small Fab - 1	5016490
2044T67	Cap Ø1.09	4.10 Ea (2 ea)	100-Small Fab - 1	5137367
51495K116	COUPLING 1/2" NCKL PLTD BRASS	2.5 Ea (1 ea)	100-Small Fab - 1	5147990
K010-0608	Hose Ø1/2 OD x Ø3/8 ID	30 ft (6 ea)	100-Small Fab - 1	5152493
PAD210	Foam Ø1 X 1	.0350 sf (.007 ea)	100-Small Fab - 1	5021250
RB H4749-1	Drain Hose Body	2.5 pcs (1 ea)	100-Small Fab - 1	5135861
9263K642	O-Ring	2.5 Ea (1 ea)	100-Small Fab - 1	5148081
M304TR0.375W.065	304 Round Tube .375 X .065W	.4150 ft (.083 ea)	100-Small Fab - 1	5145223

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	2044T47	2	29	0
	2044T67	10	113	0
	51495K116	5	43	0
	9263K642	5	28	0
	K010-0608	30	285	0
	M304TR0.375W.065	0	60	0
	PAD210	0	12	0
	RB H4749-1	5	2	0

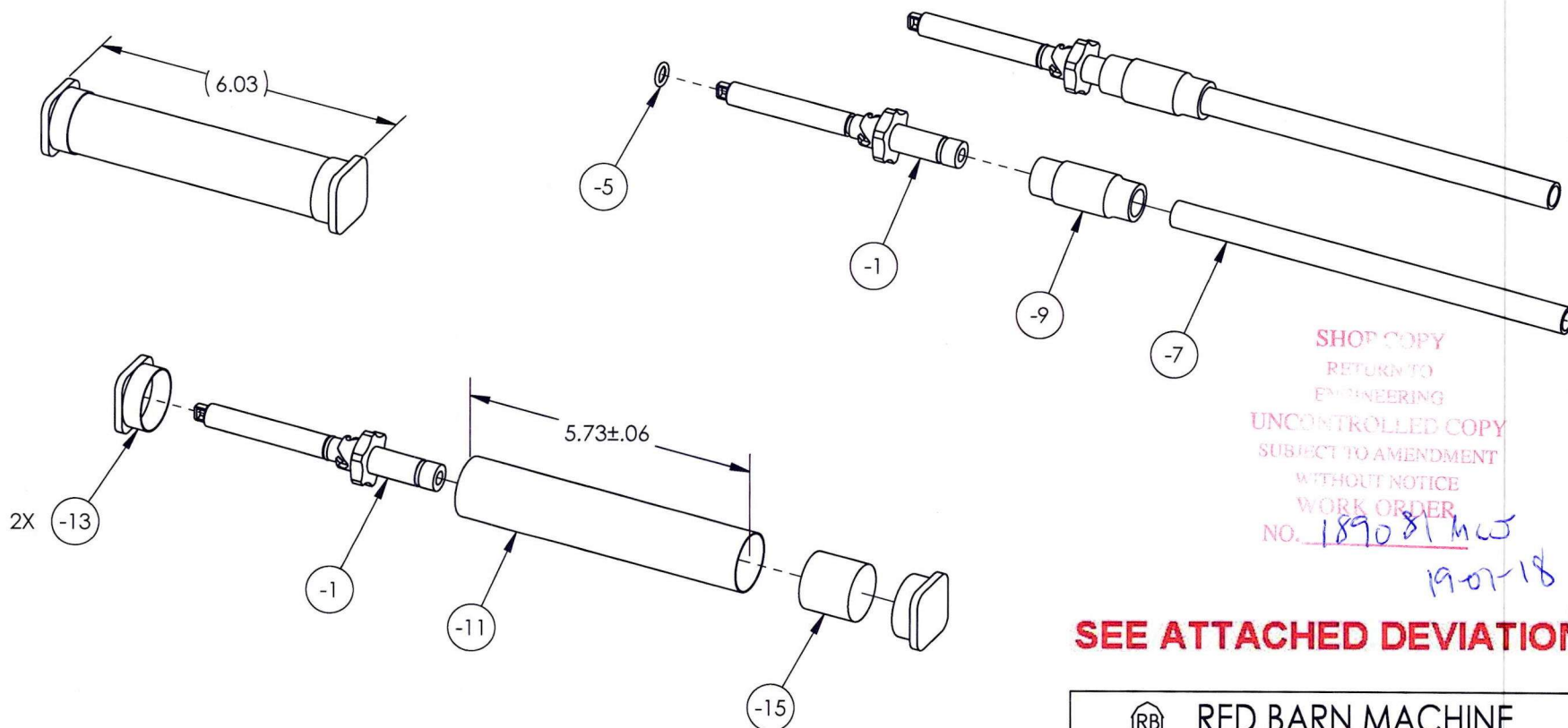
Part Specifications

Specifications could not be found.

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	DELETED ITEM #'S AND LISTED AS PART #'S, ALSO IMPLEMENTED NEW REV., BOM & TITLE BLOCK	9/21/07	WP	RW
2	DELETED -3 COLLAR, & ADDED -9 CLAMP, REFORMATED DIMENSIONS & ADDED ASSY VIEW	7/24/2012	WP	RW
3	CH'D TOOL NUMBER FROM H4749 PER E.B. CH'D ANGLE OF NOTCH FROM 60° TO 90° PER G.E.	7/24/2012	RJC	RW
4	MODIFIED -1 TO USE WITH COUPLING, ADDED COUPLING, TUBE, AND CAPS, REMOVED HOSE CLAMP.	7/24/2012	JAG	SE
5	-1 ADDED MISSING DIM $\varnothing .312$, CH'D DIM WAS .125 IS .125+/.005/- .000 ∇ .090.	2/26/2013	BIM	JG
5A	CH'D -11 LENGTH FROM 5.83 TO 5.73 & -15 MATERIAL. -1 CH'D TOL TO 2 PLC ON 1.35, .05, & 4.98, DP 4.935 TO 4.93 MAX, WAS $\varnothing 1.062$ IS $\varnothing 1.06$. CH'D NOTES WAS ENGRAVE P/N IS ENGRAVE T/N, S/N, "MADE IN USA", WAS 6X R.375 EQUALLY SPACED IS 6X R.38 EQUALLY SPACED ON $\varnothing 1.60$ B.C. DELETED .244, .096.	1/30/2014	JAG	GE



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BODY	6061	$\varnothing 1-1/8 \times 5-1/8$	2
		B/O	-5	1	O-RING	VITON	2-011N70 OR MCMaster-CARR #9263K642	1
		B/O	-7	1	HOSE	VINYL	$\varnothing 1/2$ O.D. x $\varnothing 3/8$ I.D. x 6ft KURI-TECH #K010-0608	1
		B/O	-9	1	COUPLING	NICKEL-PLATED BRASS	$\varnothing 1/2$ MCMaster-CARR #51495K116	1
		B/O	-11	1	TUBE	POLYETHYLENE	$\varnothing 1.09$ MCMaster-CARR #2044T47	1
		B/O	-13	2	CAP	VINYL	$\varnothing 1.09$ MCMaster-CARR #2044T67	1
		B/O	-15	1	FOAM	POLYESTER/POLYURETHANE	$\varnothing 1 \times 1$ NEW PIG CORP. #PAD210	1

RED BARN MACHINE	
TITLE TRANS. & GEAR BOX DRAIN TOOL	
DWG NO. RB H4749	REV 5A
DRAWN BY: D. ROBERTS	
APPROVED D. Weil	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX $\pm$.005 FRACTIONS $\pm$ 1/32 .XX $\pm$.01 ANGLES $\pm$ 5° .X $\pm$.1 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SPEC	
USED ON MODEL BELL 407	
SCALE 1:3	DATE 2/28/2000
SHEET 1 OF 2	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					